



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2939-2BL
Job Sheet 186108



Part No: D2939-2BL

Job Qty: 3 ea

Part Name: Saddle RH In, 206



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/9/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Machining-1		SBL 18/11/25
100	CNC Vertical Machining	3 pcs	12/14/18	12/14/18	0.45	3.30	HAAS1-2		SBL 18/11/25
110	Mill Conv	3 pcs	12/14/18	12/14/18	0.00	3.30	Mill Conv 1		SBL 18/11/25
120	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC1		SBL 18/11/25
130	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC8 Machining-1		SBL 18/11/25
140	HandFinish	3 pcs	12/14/18	12/14/18	0.00	0.09	HandFinish1		DR 18/11/26
150	Outsource	3 pcs	12/14/18	12/14/18			ATE003-VC		DEC 03 2018
155	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging2		DEC 03 2018
160	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC14		DEC 03 2018
170	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-1		DEC 03 2018
180	QC21-SA	3 Ea	12/14/18	12/14/18	0.00	0.00	QC21		DEC 03 2018

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - ** MASK ALL HOLES AS PER PAR16-484***

DEC 04 2018

DAS
21
2-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	3 Ea (1 ea)	90-Start up Operation	50386502 5/31/2025

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-001	3	64	0

Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

						DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Work Order: _____																	
Part No. _____								DART AEROSPACE Container No: S131226 Part: D2939 - 2BL Job No: 186108 Serial No/Batch: S131226 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 11/24/18 Dart Aerospace Ltd. 1270 Aberdeen Street Hewlettsbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com									
NCR No. _____								Water Jet _____ Prod. Eng. Coord. _____ Rec/Store/Packaging Supplier _____ Engineering Quality Other _____									
Date : _____								MRB (QS1042) Approval _____									
								Completed By _____									
								Lead hand / Supervisor Approval Verification _____									
								QC / QA Coordinator Approval _____									
Root Cause						FAULT CATEGORY											
Environment	No Re-verfication	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong												
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions												
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance												
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect												
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing												
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved												
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing												
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish												
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread												
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence												
Past Expiry Date	Manufacturing Process																
Misidentified	Past Due	OTHER :															

DART AEROSPACE LTD				Work Order: 186108	
Description: 206 Saddle, Inboard, Right side				Part Number: D2939-2	
Inspection Dwg: D2939 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.119	.119	.120		
B	0.100	0.140		.119	.119	.118		
C	0.100	0.140		.110	.112	.112		
D	0.210	0.230		.223	.222	.223		
E	1.245	1.255		1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257		
L	0.312	0.317		.312	.312	.312		
M	0.235	0.240		.238	.239	.236		
N	0.100	0.140		.120	.120	.120		
O	0.540	0.560		.549	.550	.550		
P	0.490	0.510		.499	.498	.498		
Q	3.715	3.725		3.720	3.720	3.720		
R	2.720	2.760		2.742	2.742	2.742		
S	0.240	0.270		.252	.252	.252		
T	0.100	0.180		.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316		
X	1.250	1.270		1.260	1.260	1.260		
Y	1.565	1.585		1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188		
AA								
AB								
AC								
AD								

Measured by: DAS 57 18/11/25		Date: 18/11/25	
Audited by: 9-89 ank		Date: 18/11/25	
Prototype Approval: N/A		Date: N/A	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041880**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041880
PO Date: 11/28/18
Due Date:
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186184	D4308-042BL	Step, RH Crew : Various STC's As per Dwg D4308 Rev A Prime and Spray Paint Delfleet Blue	Firmed	-		6 pcs	0 pcs	6 pcs	\$40.00/pcs	\$240.00
2	186170	D2646BL	Aft Cap : Various STC's	Firmed	-		6 pcs	0 pcs	6 pcs	\$21.00/pcs	\$126.00
3	186109	D3413-1BL	O-Ring : Various STC's SPRAY PAINT BLUE BATCH: _____	Firmed	-		10 pcs	0 pcs	10 pcs	\$15.00/pcs	\$150.00
4	186107	D2939-1BL	Saddle LH In, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO _____	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
5	186101	D2932-1BL	Saddle LH Out, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** BATCH: _____	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
6	186103	D2933-1BL	Saddle LH In, 206 : Various STC's *** MASK ALL HOLES AS PER PAR16-484*** BATCH: _____ ISSUE PO _____	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
7	186106	D2938-2BL	Saddle RH Out, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO _____	Firmed	-		3 pcs	0 pcs	3 pcs	\$25.00/pcs	\$75.00



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PURCHASE ORDER **PO041880**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	186105	D2938-1BL	Saddle LH Out, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	-	4 X DEC 03 2018	4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
9	186102	D2932-2BL	Saddle RH Out, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** SPRAY PAINT BLEU	Firmed	-	3 X DEC 03 2018	3 pcs	0 pcs	3 pcs	\$25.00/pcs	\$75.00
10	186108	D2939-2BL	Saddle RH In, 206 : Various STC's ** MASK ALL HOLES AS PER PAR16-484***	Firmed	-	3 X DEC 03 2018	3 pcs	0 pcs	3 pcs	\$25.00/pcs	\$75.00
Grand Total: \$1,141.00											

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/28/18 1:16 PM dart.tsimiklis.chrisoula

